



SERDP / ESTCP WORKSHOP

FEBRUARY 27 2008

MESSIER-DOWTY / HVOF IMPLEMENTATION

Report Documentation Page				Form Approved OMB No. 0704-0188	
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1. REPORT DATE 27 FEB 2008		2. REPORT TYPE		3. DATES COVERED 00-00-2008 to 00-00-2008	
4. TITLE AND SUBTITLE Messier-Dowty/HVOF Implementation				5a. CONTRACT NUMBER	
				5b. GRANT NUMBER	
				5c. PROGRAM ELEMENT NUMBER	
6. AUTHOR(S)				5d. PROJECT NUMBER	
				5e. TASK NUMBER	
				5f. WORK UNIT NUMBER	
7. PERFORMING ORGANIZATION NAME(S) AND ADDRESS(ES) Messier-Dowty Inc.,SAFRAN Group,574 Monach Avenue,AJAX, Ontario L1S 2G8, Canada,				8. PERFORMING ORGANIZATION REPORT NUMBER	
9. SPONSORING/MONITORING AGENCY NAME(S) AND ADDRESS(ES)				10. SPONSOR/MONITOR'S ACRONYM(S)	
				11. SPONSOR/MONITOR'S REPORT NUMBER(S)	
12. DISTRIBUTION/AVAILABILITY STATEMENT Approved for public release; distribution unlimited					
13. SUPPLEMENTARY NOTES Surface Finishing and Repair Issues for Sustaining New Military Aircraft Workshop, February 26-28, 2008, Tempe, AZ. Sponsored by SERDP/ESTCP.					
14. ABSTRACT					
15. SUBJECT TERMS					
16. SECURITY CLASSIFICATION OF:			17. LIMITATION OF ABSTRACT Same as Report (SAR)	18. NUMBER OF PAGES 14	19a. NAME OF RESPONSIBLE PERSON
a. REPORT unclassified	b. ABSTRACT unclassified	c. THIS PAGE unclassified			

■■■■ MESSIER-DOWTY, PRODUCTION FACILITIES

▶ Bidos, France

- Manufacturing centre for shock strut / shock absorber
- HVOF requirements on pistons for various programs
- M-D currently considering to invest into HVOF technology

▶ Gloucester, United Kingdom

- Manufacturing centre for axles / truck beam (bogie beam)
- HVOF requirements on axles for various programs

▶ Toronto, Canada

- Manufacturing centre for business, regional and military programs
- Assembly line for the B787 program
- HVOF requirements on a wide range of components
- One HVOF booth

▶ Montreal, Canada

- Manufacturing centre for cylinders (main fittings) on Airbus / Boeing commercial program
- HVOF requirements still in the early phase due to size of the components

▶ Suzhou, China

- Manufacturing centre for non complex components on various program
- HVOF investment being considered

■■■■ MESSIER-DOWTY, HVOF REQUIREMENTS

► Existing programs

- Falcon 7X (Dassault) – Business program
- A380 Nose Gear- Commercial program
- A400M Main & Nose Gear – European military program
- B787 – Commercial program
- A350 Main Gear – Commercial program

► **Every new program at Messier-Dowty will require HVOF coating as replacement to chrome plating whether it is a European or North American programs**

► Still some exceptions on large components

- Internal small bores (micro gun ???)
- Internal diameter on cylinders (ID gun ???)
- Spigot (rotating equipment ???)
- OEM will require eventually such exceptions to be removed and converted to HVOF

■ ■ ■ ■ ■ MESSIER-DOWTY, GEOGRAPHY VS MARKET

▶ **M-D located in 3 distinct geographic areas**

- North America
- United Kingdom
- Western Europe

▶ **European approach to HVOF technology**

- HP technology (kerosene system) superior to LP technology (hydrogen system)
- Market dominated by Praxair JP 5000 / 8000 and / or SM Woka Jet 350 / 400
- Approval process strenuous for potential suppliers

▶ **North American approach to HVOF technology**

- Participation to HCAT
- LP technology and HP technology are comparable
- Simplification of the approval process for potential suppliers

▶ **Approval process has been simplified**

■■■■ MESSIER-DOWTY, APPLICABLE SPECIFICATIONS

▶ HVOF THERMAL SPRAY – PCS 2560

- Application of tungsten carbide cobalt chromium coatings on metallic parts by High velocity oxygen / fuel (HVOF) process
- Largely inspired by AMS 2448

▶ QUALIFICATION PLAN FOR PCS-2560 SUPPLIERS

- Stipulates M-D approval process and commercial requirements

▶ HVOF POWDER – PCS 2561

- Tungsten Carbide Cobalt Chrome Powder, Agglomerated and Sintered
- 86 WC – 10Co – 4Cr
- Largely inspired by AMS 7882

▶ GRINDING REQUIREMENTS – PCS 4102

- Grinding of HVOF Sprayed Tungsten Carbide Coatings applied to Steel

MESSIER-DOWTY, HVOF REQUIREMENTS

► FUTURE REQUIREMENTS

Sites	Number of parts		
	2008	2009	2010
Montreal	158	286	445
Bidos	204	381	596
Gloucester	1 750	3 600	6 200
Toronto	330	330	330
Suzhou		1 800	9 300
Total	2 442	6 397	16 871

Montreal	Main Fittings	A350 / A380 / B787
Bidos	Sliders	A350 / A380 / B787 / F7X / A400M
Gloucester	Pins	A350 / B787
Toronto	Main Fittings + Trailing Arm + Piston	F7X
Suzhou	Pins	B787

Excludes indirect requirements for A400M / A380 / F7X program.
Estimated to an additional 5 800 parts in 2010.

■ ■ ■ ■ ■ MESSIER-DOWTY, QUALITY SYSTEM REQUIREMENTS

▶ COMPLIANCE TO PRIDE MANUAL

- Process Requirements In Developing Excellence
- Stipulates Messier-Dowty quality requirements for suppliers

▶ AS 9100 APPROVAL REQUIRED TO BECOME M-D SUPPLIER

- EN 9100, AS9100 or JISQ9100
- Prerequisite to become a M-D approved HVOF spray supplier
- Immediate requirement

▶ NADCAP ACCREDITATION

- All special processes shall be certified NADCAP by target dates
- Target data for HVOF: December 31st, 2008
- Mandatory requirement from Boeing for B787 components

■■■■ MESSIER-DOWTY, COMMERCIAL REQUIREMENTS

► SUPPLIER TO BE RESPONSIBLE FOR THE FOLLOWING ACTIVITY

- HVOF Thermal Spray per PCS-2560
- HVOF Grinding, Super Finishing and Inspection per PCS-4102
- Surface Texture Inspection per PCS-2565
- Magnetic Particle Inspection (MPI – if required) per PCS-3100 (or equivalent)
- Grinding and Super Finish could be sub-contracted by HVOF spray shop
 - Grinding source to be approved by Messier-Dowty
 - HVOF spray shop still commercially responsible for quality of products
- MPI could be sub-contracted to a M-D approved source

■ ■ ■ ■ HVOF – SUPPLIERS REQUIREMENTS

► MESSIER-DOWTY ‘MAKE’ PARTS

- Messier-Dowty ‘MAKE’ parts are parts machined by M-D facilities. These parts are typically very large and heavy and require handling to manipulate
 - M-D BIDOS (France): Sliders or piston (Straight shape or T shape)
 - M-D Gloucester (UK): Axle (long cylindrical component) and truck / bogie beam
 - M-D Montreal (Can): Cylinders or Main Fittings
- M-D outsourcing requirements is only for HVOF spray since M-D already owns grinding equipment
- Even if M-D invest into HVOF technology, outsourcing will still be required

■ ■ ■ ■ HVOF – SUPPLIERS REQUIREMENTS

► MESSIER-DOWTY ‘BUY’ PARTS

- Messier-Dowty ‘buy’ parts are components machined and assembled by M-D various suppliers
- Most of these suppliers do not have processing capability. Special process shall be conducted through approved M-D suppliers
- Several small suppliers with limited resources to manage sub-tiers.
- M-D would prefer to have ‘one-stop shop’ taking care of all operations:
 - Nital etch, MPI, shot peen, HVOF, grind, inspection, cad plating, paint, etc...
- Bare minimum: HVOF, grind, inspect & NDT

■ ■ ■ ■ ■ HVOF – SUPPLIERS REQUIREMENTS

▶ QUALIFICATION PROCESS

- Supplier to present a plan with minimum processing services
- Plan to be reviewed by M-D
- M-D lab and QA to audit suppliers to ensure that quality and processing are acceptable
- Design for experiment (DOE) to be completed by suppliers to demonstrate optimization and repetitiveness of spray parameters
- Supplier to procure material and machined to round axial specimens (ASTM-E-466)
- Supplier to spray the test samples
- Supplier to sub-contract samples testing to approved M-D laboratories
- Upon completion of the tests and acceptable results, notification of conditional approval to be sent by M-D
- Corrective actions from previous audits to be closed
- Final approval

■ ■ ■ ■ HVOF – SUPPLIERS REQUIREMENTS

▶ ADDITIONAL QUALIFICATION PROCESS INFORMATION

- Approval process is material specific
 - Approval process for 300M is valid for low carbon steel and all stainless steel
 - Approval process for titanium
 - Approval process for Custom 465
 - A given supplier could pass its approval for steel substrate but fail for titanium substrate
- First few pieces to be coated and ground by a new supplier will have to be Rollscan
 - Barkhausen Noise Test
 - Activity to be done by supplier at its facility or at M-D facility
- Within 12 months of conditional approval, suppliers will be requested to purchase and install on-line monitoring equipment for thermal spray booths
 - Accura Spray
 - Spray Watch

■■■■ MESSIER-DOWTY, LESSONS LEARNED

- ▶ Capacity available in the marketplace is limited
 - Lots of spray shop in the market
 - Capacity to meet aerospace reqs is more difficult than traditional spray market
 - Developing a good new supplier is a lengthy process
- ▶ Never split between spray source and grind source
- ▶ Consider spray and grind as two separate markets
 - Capacity problem is probably even more severe for grinding
 - Lots of grinding knowledge in the market for chrome
 - Transition from chrome grinding to HVOF grinding is not easy
- ▶ Start your supply chain development very early in the process
 - B787 program highlighted this need due to rapid program in monthly build-up rate
- ▶ Dedicate full-time resources to the assignment
- ▶ Preference for the one-stop shop concept

■■■■ MESSIER-DOWTY, CONCLUSION

- ▶ Still looking for suppliers willing to embrace the challenge
- ▶ M-D business model calls for supply chain to grow
 - US dollar zone
 - Emerging countries (LC) zone
- ▶ Areas of development in dollar zone
 - West Coast
 - Mid-West
 - North-East
- ▶ Areas of development in LC zone
 - Mexico
 - India
 - China